

Date: Tuesday, 4/18/2006 10:00:08 AM
 By: Kim Johnston

Process Sheet

20

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY HIGH SKID RH
 Job Number : 26656
 Estimate Number : 10720
 P.O. Number : N/A Part Number : D350591214
 This Issue : 4/18/2006 S.O. No. : N/A Drawing Number : D3078 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 25434 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 5/20/2006 Qty: 10 Um: Each
 Checked & Approved By : J. 06.04.18
 Comment : Est Rev: B 05.10.14 Modified step 10 KJ/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-214 CHG001

CHG001

KS 06.05.10

10

2.0 D2622120C Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

.5 D2622-120 Extrusion 324563

S.E. 06.05.11 10

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

S.E. 06.05.11 10
 S.E. 06.05.11 10
 S.E. 06.05.11 10

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S.E. 06-05-11 10

5.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:00:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 26656

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1 End Plate 326411

SE-06-05-11

10

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support 324353

SE-06-05-11

10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

SE-06-05-11

10

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078

SE 06-05-12

10

A/R Aluminum Rod ~~M15689~~
M15689

3-Grind End Plate flush

SE 06-05-16

10

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

SE-05-18 (10)

SE 06/05/18 (10)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SE-06-05-18

10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE-05-23 (10)

11.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy 326452

SE-06-05-23

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:00:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 26656

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

326258

PE. 06.05.23

10

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M18499

PE. 06.05.23

10

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

PE 06.05.23

10

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-24

10

16.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

26411

PE. 06.05.24

10

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M19173

PE 06.05.24

10

PE 06.05.24

10

PE 06.05.24

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:00:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 26656

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Grind End Plate flush

18.0

QC5/9

WELD INSPECTION



FE. 06.05.24 = 2

FF. 06.05.29 = 8



Comment: Inspect work & Weld to Current - Check dimension 108.93" & 3.375" as per Dwg D3272

10/06/05/20 (10)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

FF 06.05.30

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/02 (10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

FC 06 06 05

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

10/06/06/10 (10)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.3000 f(s)/Unit Total: 3.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2182b035 Rubber Cushion *B24870*

SEE ATTACHED

PU

25.0

D2274

Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2274 Radius Block *B25709 7mcs*

B26078 mcs

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, 4/18/2006 10:00:09 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 26656

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 D2732 Rubber Extrusion



Comment: Qty.: 0.2500 f(s)/Unit Total: 2.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2732-030 Rubber Cushion

B26472

27.0 D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

B26041

28.0 D30641 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3064-1

Clamp

~~B23404~~
B23404

29.0 D30801 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3080-1

Clamp

B25453 3m
B21677 17m

30.0 AN335A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN3-35A

Bolt

M19551

31.0 AN411A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

M14783 8m

M17771 52m

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 26656

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M15875 1mcp

M16895 3mcp

M16822 14

33.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M100570-

34.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M100393

35.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M19085

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location: FG 34

PPP Rev: B

M106/6/6 (10)

Date: Tuesday, 4/18/2006 10:00:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 26656

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/06/07 (18)

Job Completion



U 06.06.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 01/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

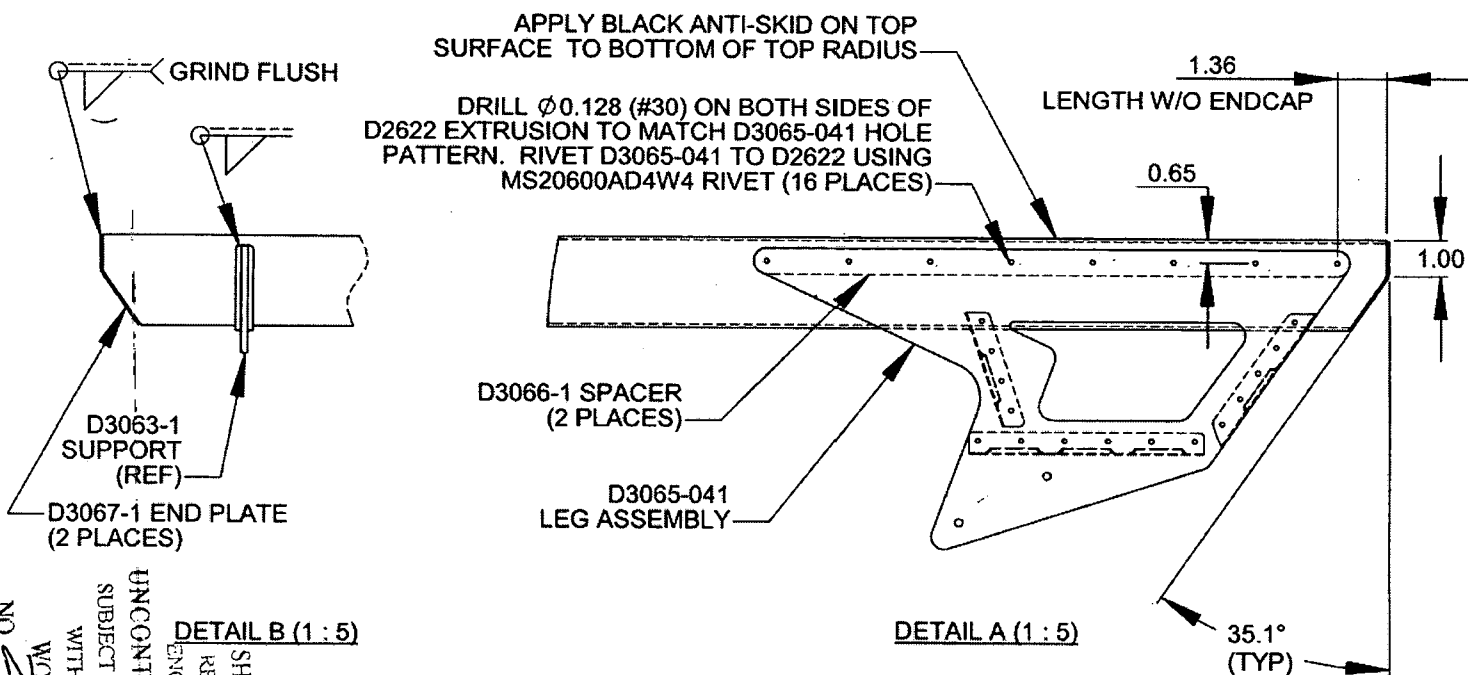
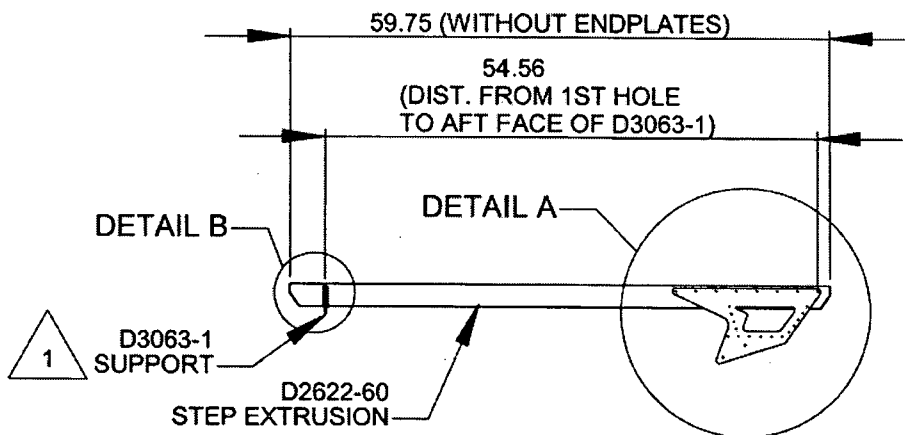
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WORK ORDER
NO. *26656*

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DART

DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

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02.07.2004

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WORK ORDER
NO. **26656**

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Date: Friday, 6/23/2006 3:02:21 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Job Number : 27682 Estimate Number : 10804 P.O. Number : N/A This Issue : 6/23/2006 S.O. No. : N/A Prsht Rev. : NC First Issue : 6/23/2006 Type : N/A Previous Run : 00015 Written By : <u>SEE ABOVE WORK & DATE</u> Checked & Approved By : _____ Comment : _____	Drawing Name : D350-591-211/-212/-213/-214/-215/-216 Part Number : Z_CUSTOM Drawing Number : ADD PARTS & PAPERWORK Project Number : N/A Drawing Revision : N/A Material : N/A Due Date : 6/30/2006 Qty: 24 Um: Each	
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	DSI9340011	STEP MOD KIT
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s) STEP MOD KIT		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 ADD TO KITS IN STOCK 1 X DSI 9340-011 B <u>27681</u> STOCK AFFECTED: D350-591-211 (4 X B18906) <u>OK</u> D350-591-212 (0) D350-591-213 (6 X B27432) <u>→ 5</u> D350-591-214 (7 X B26656 / 2 X B25434) <u>OK</u> D350-591-215 (2 X B26681) <u>→ 1</u> D350-591-216 (2 X B25753 / 1 X B26732) <u>OK</u>		
Remove: D2182 B035 D3080-1 D3064-1 Add new labels 22 new 24/6/26		
3.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
 		
Comment: INSPECT 100% KITS FOR COMPLETENESS		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 REPACKAGE PER FPP & RETURN TO STK		
8X B18755 4X B23406 4X B26667 D3064-1 27681 22 new 24/6/26 (22) Add per		